

Work Order ID 51452

August 24, 2009 3:48:45 PM



Page 1

Item ID: D3646-3 *BK*

Revision ID: B

Item Name: Arm

Start Date: 08/24/2009 Start Qty: 5.00

Required Date: 08/25/2009 Req'd Qty: 5.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:



Approvals: Process Plan: *mf*

Date: *09-08-24*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3646	Rev A

100 0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch to length as per Dwg D3646 & template DT8959

m.k

09/09/03

(SX)

110 0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr

2- Bend as per dwg D3646

m.k

09/09/03

(SX)

m.k

09/09/03

(X)

120 0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

2) 8/21/08

(X)

(X)

(P10) ->

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3646-3 PAR #: _____ Fault Category: Prod. Small Cal NCR: Yes No DQA: _____ Date: 05-05-16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 05-05-16

NCR: 51452		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/9/13	110	Flange / A / A Arm Bent / Fabrication 112 too short. Flange was not Stew S.						
9/9/13	110	One part scrap. Arm was made too short by .350" on the upper bend. Ends cut after bending. R.C.: Lack of Attention.	<u>09.09.03</u>	Scrap And Destroy - Replace B# <u>112187</u>	<u>M.H</u> <u>09/09/13</u>	<u>09/09/13</u>	<u>09.09.03</u>	<u>09/09/13</u>

NOTE: Date & initial all entries

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Item ID: D3646-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Arm

Start Date: 08/24/2009 Start Qty: 5.00



Cust Item ID:

Required Date: 08/25/2009 Req'd Qty: 5.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo START TIME: 7:30AM OVEN TEMPERATURE: 320°F FINISH TIME: 8:00AM	0.00 0.00		09/09/10		25	0		
140 QC Quality Control	QC3- Inspect Part Finish Memo 09-09-10	0.00 0.00		5.					
150 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							24/9/10 (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51452

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Item ID: D3646-3

Accept

Revision ID: B

Item Name: Arm

Start Date: 08/24/2009 Start Qty: 5.00

Required Date: 08/25/2009 Req'd Qty: 5.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/09/10
MF 09-09-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 51452



Parent Item: D3646-3RevB



Parent Item Name: Arm

Start Date: 08/24/2009

Required Date: 08/25/2009

Comments:

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			110	f	283.0441	15.3158			



304 RD Tube .500 x .035W



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

283.0441097

108250

2.23

111097

24.687936

111704

31.6682737

112187 ✓

224.4579

m. h 09/09/03

M 112187

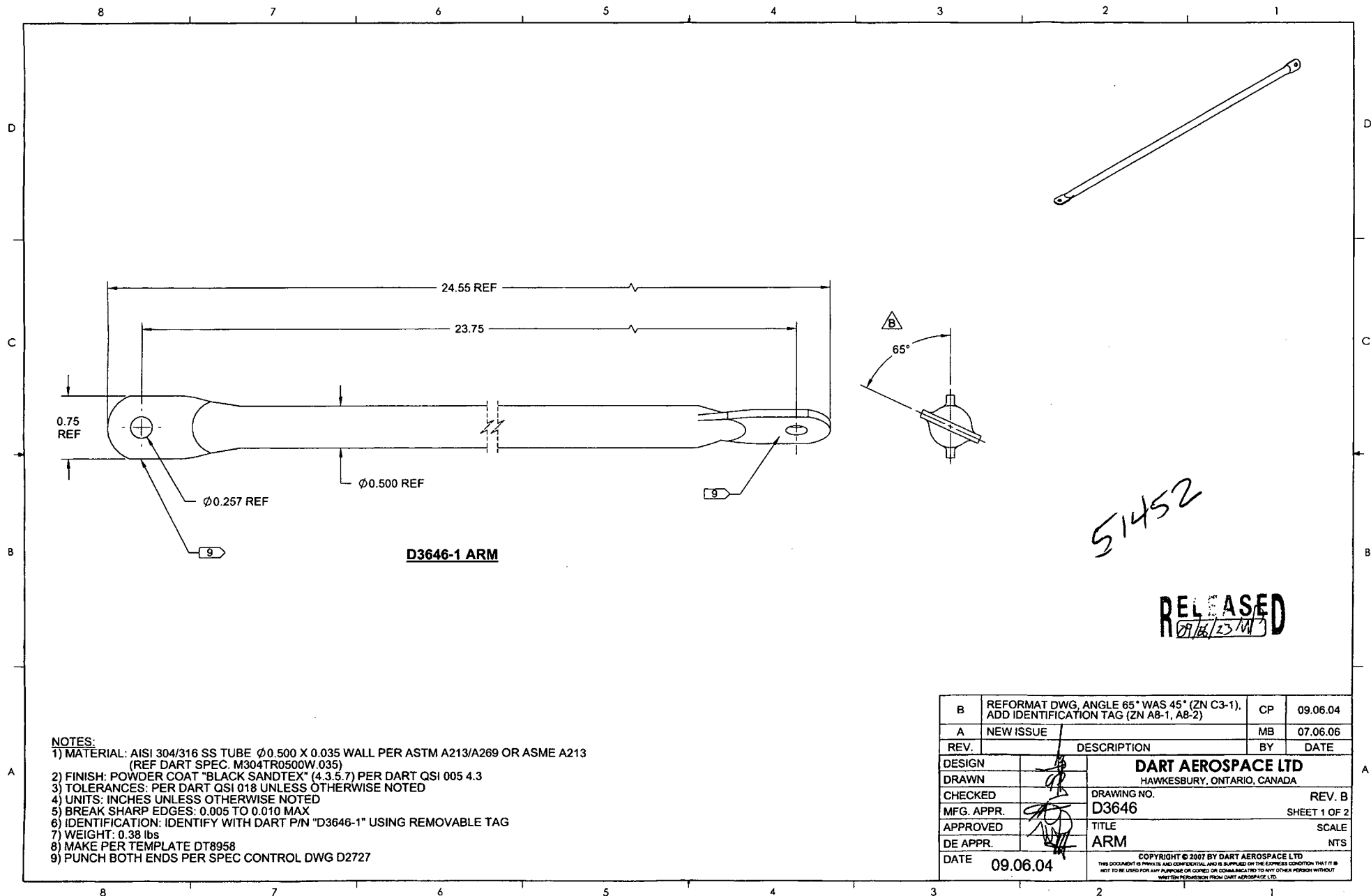
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



NOTES:

- 1) MATERIAL: AISI 304/316 SS TUBE $\phi 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
- 2) FINISH: POWDER COAT "BLACK SANDEXT" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.38 lbs
- 8) MAKE PER TEMPLATE DT8958
- 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

B	REFORMAT DWG, ANGLE 65° WAS 45° (ZN C3-1), ADD IDENTIFICATION TAG (ZN A8-1, A8-2)	CP	09.06.04
A	NEW ISSUE	MB	07.06.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3646	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	09.06.04	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

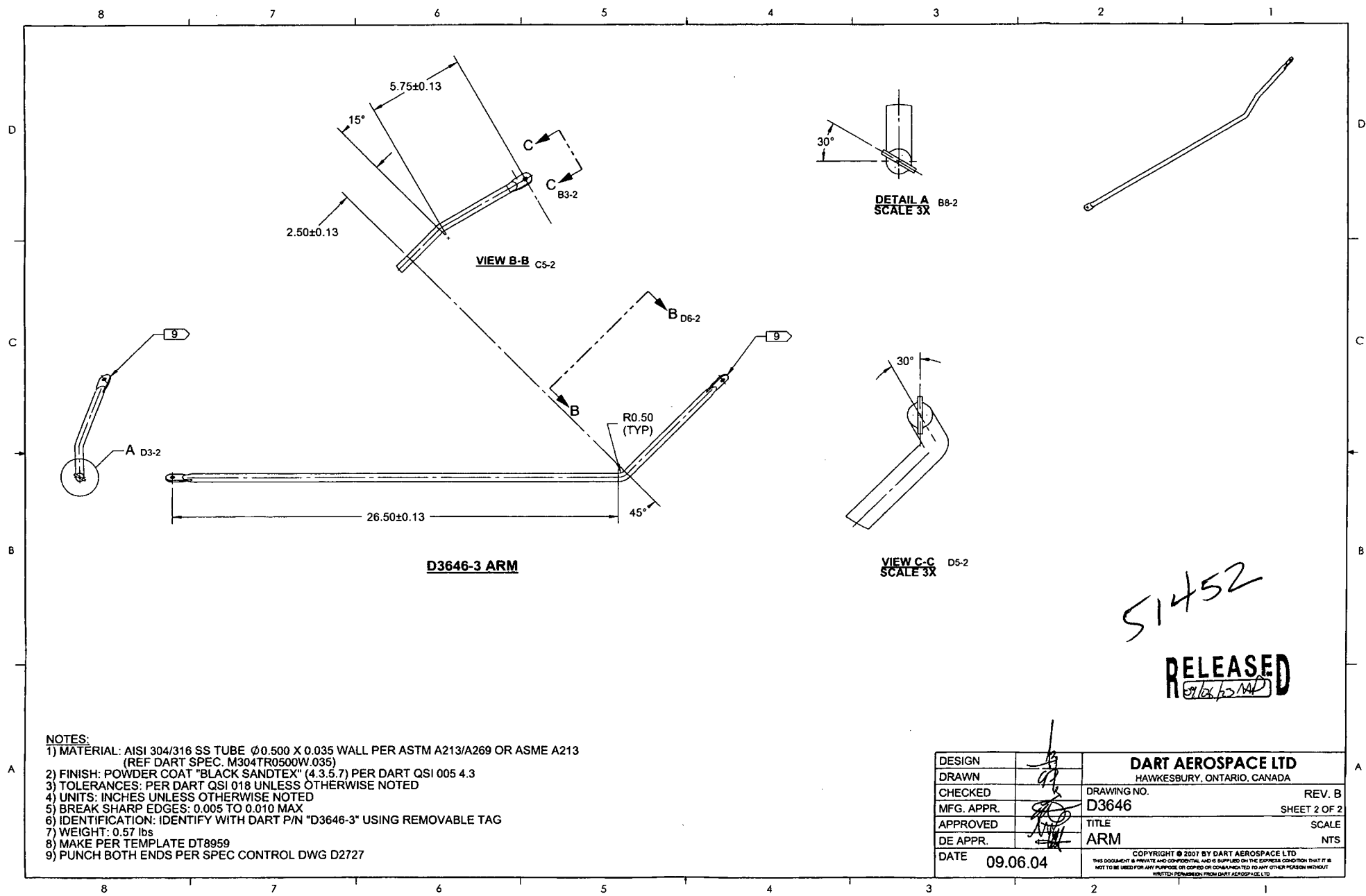
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



D3646-3 ARM

DETAIL A
SCALE 3X

VIEW C-C
SCALE 3X

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS TUBE $\varnothing 0.500 \times 0.035$ WALL PER ASTM A213/A269 OR ASME A213 (REF DART SPEC. M304TR0500W.035)
 - 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3646-3" USING REMOVABLE TAG
 - 7) WEIGHT: 0.57 lbs
 - 8) MAKE PER TEMPLATE DT8959
 - 9) PUNCH BOTH ENDS PER SPEC CONTROL DWG D2727

51452
RELEASED
97/06/02 MJD

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3646	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	09.06.04	<small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
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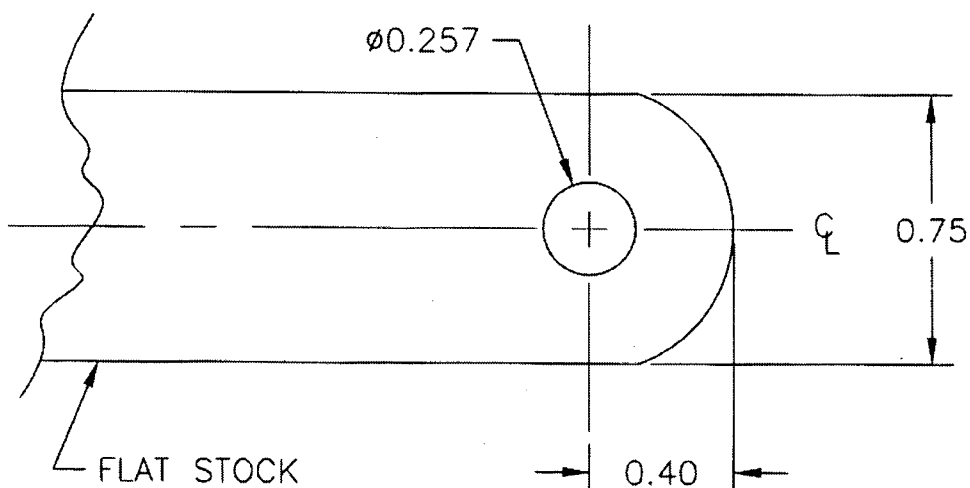
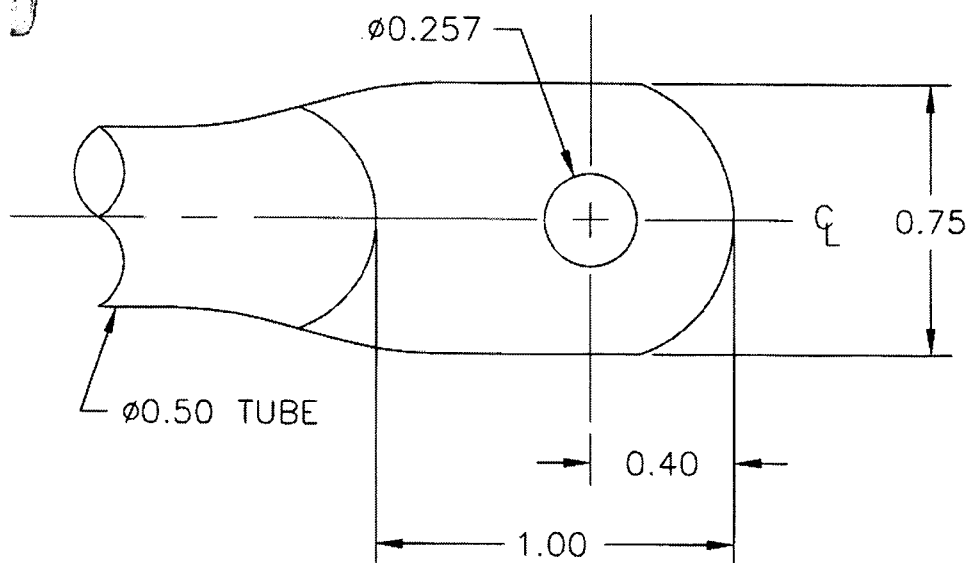
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DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DM</i>	APPROVED <i>KA</i>	DRAWING NO. D2727	REV. A SHEET 1 OF 1
DATE 97.11.24		TITLE PUNCH DT8012 SPEC CONTROL	SCALE 2:1
A	97.11.24	NEW ISSUE	
A1	<i>tip</i> 01.12.20	ADD TOLERANCE NOTE	

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/00 KE



51452

NOTE: TOLERANCES ARE PER DART QSI OIB UNLESS OTHERWISE NOTED.

